

BLUE

Dart Aerospace Ltd.

23

Date: Wednesday, 5/16/2007 8:14:40 AM
User: Kim Johnston

Process Sheet

SPLIT-1

Customer : CU-DAR001 Dart Helicopters Services

Job Number : 32383 - 1

Estimate Number : 10939

P.O. Number : N/A

This Issue : 5/16/2007

Prsht Rev. : NC

First Issue : N/A

Previous Run : 30481

Written By : J. Jones

Checked & Approved By : J. Jones

Comment : Est: B 00.06.26 New DWG rev (mpp 2069) EC
Est Rev: C As per Rev C 07-03-19 JLM

Drawing Name : 206/OH-58 SADDLE, INBOARD, RIGHT SIDE - UNDER REVIEW

Part Number : D29382

Drawing Number : D2938 REV C

Project Number : N/A

Drawing Revision : C

Material : N/A

Due Date : 6/16/2007

Qty: 16 Umt: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D6101003 7075-T7351 2X6.25X7.875



Comment: Qty: 1.0000 Each(s)/Unit Total: 16.0000 Each(s)

Issue material from stock: 7075-T7351 (QQ-A-250/12)

Cut Size 2.0" x 6.25" X 7.88" Grain Along 7.88" Length

(D6101-003)

Batch No: 331387

mk 07/06/25

2.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Program part number and batch number.

1-Inspect part number and batch number are programmed correctly.

2-Machine Step No 1 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet

3-Machine Step No 2 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet

4-Machine Step No 3 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet

5-Deburr

mk 07/06/25

3.0 MILLING CONV. CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Machine Keyway and inspect per attached dimension sheet

mk 07/06/25

4.0 QC1 INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

mk 07/06/25

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Drawing Name: 206/OH-58 SADDLE, INBOARD, RIGHT SIDE - UNDER
REVIEW

Job Number: 32383

Part Number: D29382

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

JA 07.06.26

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

m.p 07/06/27

7.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

P104058 c207/06/27 @

-PRIME

-PAINT DELFLEET BLUE

-CLEAR DELFLEET

8.0

QC14

INSPECT SPRAY PAINT



Comment: INSPECT SPRAY PAINT

JA 07.07.03 @

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

P 7/7/4 @

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

RD 07/07/04 @

Job Completion



u 07.07.04

DART AEROSPACE LTD	Work Order: 32383
Description: 206 Saddle, Outboard, Right side	Part Number: D2938-2
Inspection Dwg: D2938 Rev. C	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		0.127	0.126	0.126	0.126		
B	0.100	0.140		0.129	0.129	0.129	0.128		
C	0.100	0.140		0.120	0.120	0.120	0.119		
D	0.210	0.230		0.225	0.223	0.222	0.223		
E	1.245	1.255		1.249	1.250	1.249	1.250		
F	1.245	1.255		1.249	1.249	1.250	1.250		
G	2.495	2.505		2.500	2.499	2.500	2.500		
H	0.510	0.515		0.510	0.510	0.510	0.510		
I	1.572	1.582		1.575	1.576	1.575	1.575		
J	2.495	2.505		2.498	2.500	2.501	2.499		
K	0.257	0.262		0.258	0.258	0.258	0.258		
L	0.312	0.317		0.314	0.314	0.314	0.314		
M	0.235	0.240		0.239	0.240	0.239	0.240		
N	0.100	0.140		0.120	0.119	0.118	0.118		
O	0.540	0.560		0.547	0.547	0.549	0.549		
P	0.490	0.510		0.499	0.501	0.505	0.504		
Q	3.715	3.725		3.719	3.718	3.718	3.716		
R	2.720	2.760		2.744	2.742	2.745	2.743		
S	0.240	0.270		0.254	0.252	0.253	0.252		
T	0.100	0.180		0.135	0.140	0.140	0.140		
U	1.625	1.635		1.628	1.628	1.621	1.628		
V	1.362	1.372		1.368	1.367	1.366	1.366		
W	0.316	0.321		0.319	0.320	0.320	0.320		
X	1.250	1.270		1.258	1.259	1.258	1.260		
Y	1.565	1.585		1.573	1.574	1.573	1.575		
Z	0.178	0.198		0.188	0.188	0.188	0.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: <i>gmk</i>	Audited by: <i>SA</i>
Date: 07/06/25	Date: 07.06.26

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	<i>gmk</i>

DART AEROSPACE LTD		Work Order: 32383
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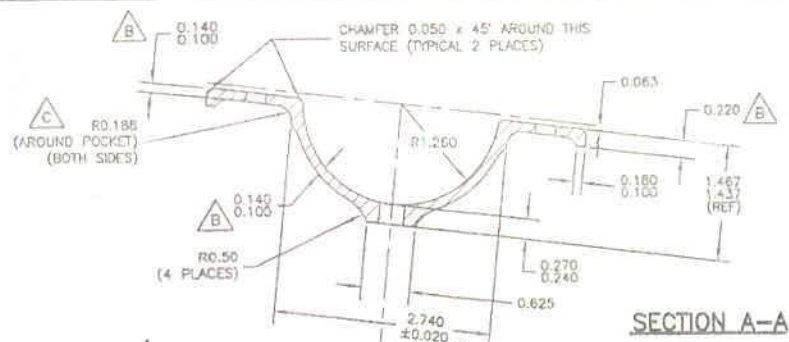
DART AEROSPACE LTD	Work Order: 32383
Description: 206 Saddle, Outboard, Right side	Part Number: D2938-2
Inspection Dwg: D2938 Rev. C	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

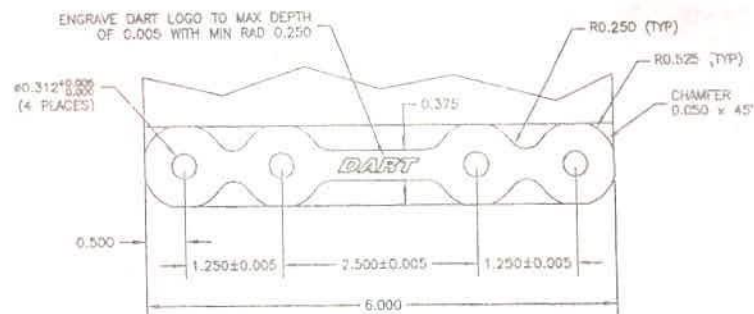
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Accept/Reject									

Measured by:	Audited by:
Date:	Date:

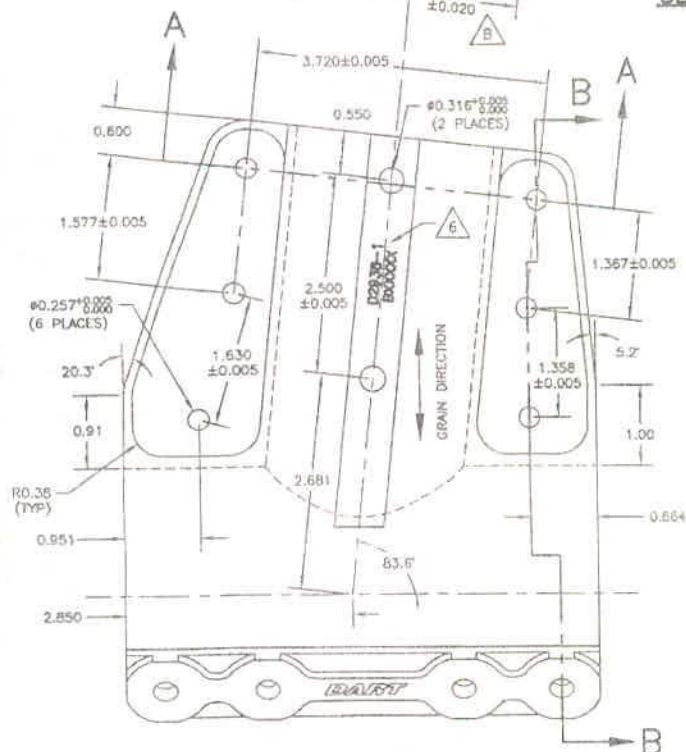
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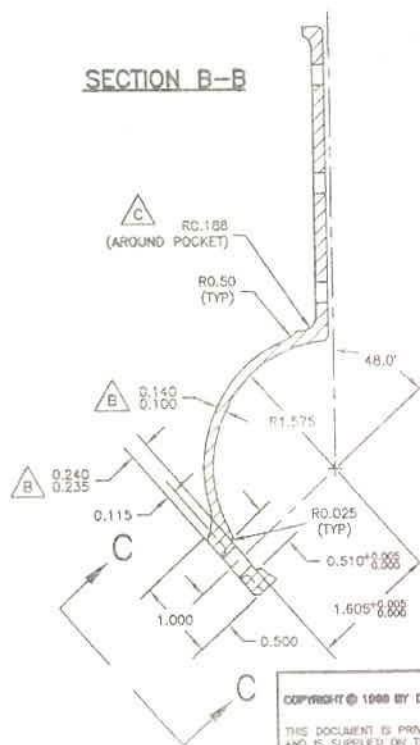
SECTION A-A



VIEW C-C



SECTION B-B



D2938-1 LH SADDLE (SHOWN)
D2938-2 RH SADDLE (OPPOSITE)

- NOTES:
- 1) MATERIAL: ALUMINUM 7075-T7351 (00-A-250/12)
(MAKE FROM D8101-003 SADDLE BULLET, 7075)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
 - 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 5) ALL DIMENSIONS ARE IN INCHES
 - 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.11.12	NEW ISSUE
DESIGN	CB	DART DART AEROSPACE USA, INC. BELLAMY, WA
CHECKED	PH	DRAWING NO. D2938
DATE	06.11.09	TITLE SADDLE OUTSIDE
		REV. C SHEET 1 OF 1 SCALE 2:3

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